



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DLL-#B-B-#-5
Job Sheet 178361



Part No: DLL-#B-B-#-5

Job Qty: 2 ea

Part Name: Thimble Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/30/18

Job Tracking No:

Due Date: 5/31/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG DLL-#-#-# Rev. A IPP Rev. A 18.05.30 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		5/31/18	0.00	0.00	Start Up Large Fab-7		DYC 18/05/30
100	HandFinish	2 pcs		5/31/18	0.00	0.20	HandFinish7		DYC 18/05/30
110	Large Fab	2 pcs		5/31/18	0.00	4.00	Large Fab 3		DYC 18/05/30
115	QC	2 pcs		5/31/18	0.00	0.00	QC9		B
120	QC	2 pcs		5/31/18	0.00	0.00	QC5		B
130	SprayPaint	2 pcs		5/31/18	0.00	0.20	Spray Paint		✓ AL MAY 30 2018
140	QC	2 pcs		5/31/18	0.00	0.00	QC14		AL 18-5-31
180	Packaging	2 pcs		5/31/18	0.00	0.00	Packaging3		DAS
190	QC21-SA	2 Ea		5/31/18	0.00	0.00	QC21		21 MAY 31 2018

Part Op 100 - 1-Bead blast, remove paint. 2-Paint on the inside of the thimble side tubes can remain.
Descriptions: 110 - 1-Weld as per DWG. 2-Grind as per DWG. 3-Remove factory markings. 4-Drill holes as per DWG. 5-Deburr.
130 - Prime and paint as per DWG. PRIME: Start Time: _____ Finish Time: _____ PAINT: Start Time: _____
Finish Time: _____ Yellow tempo: 138847 Iron Black 138823

* Please ship on Drop At Atlantic Braids *

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
7972K115	Thick-Wall Steel Unthreaded Pipe, 3/4" Pipe Size, 1' Long	.1660 ft (.083 ea)	90-Start up Operation	
7750K233				5067033

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	7972K115	0	5	0

Part Specifications



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

to be found.

Plex 5/30/18 1:32 PM dart.Lussier.Patrick

Container No: S076446



Part: DLL-#-B-B-#-5

Job No: 178361

Serial No/Batch: S076446

Revision: A

Inspector:

Exp Date: 05/30/2018

Instructions:

Date: 05/30/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. <u>DLL-#-#-#</u> NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval May 31, 2018																	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
- DLL-#-#-#-5: IN TABLE 8 DLL-#-C-A-# RETAINER P/N IS -24 SHOULD BE -23 DLL-#-D-A-# RETAINER P/N IS -25 SHOULD BE -23 DLL-#-E-A-# RETAINER P/N IS -26 SHOULD BE -24 DLL-#-F-A-# RETAINER P/N IS -27 SHOULD BE -24 DLL-#-G-A-# RETAINER P/N IS -28 SHOULD BE -25 DLL-#-H-A-# RETAINER P/N IS -29 SHOULD BE -26 DLL-#-C-B-# RETAINER P/N IS -24 SHOULD BE -23 DLL-#-D-B-# RETAINER P/N IS -25 SHOULD BE -23 DLL-#-E-B-# RETAINER P/N IS -26 SHOULD BE -24 DLL-#-F-B-# RETAINER P/N IS -27 SHOULD BE -24 DLL-#-G-B-# RETAINER P/N IS -28 SHOULD BE -25 DLL-#-H-B-# RETAINER P/N IS -29 SHOULD BE -26 - DLL-#-#-#-6: IN TABLE 9 DLL-#-#-#-22 PIPE P/N 7972K115 SHOULD BE 7972K115 AND LENGTH 1.50" SHOULD BE 0.75" DLL-#-#-#-23 PIPE P/N 7972K115 SHOULD BE 7972K116 AND LENGTH 1.50" SHOULD BE 1.00" DLL-#-#-#-24 PIPE P/N 7972K115 SHOULD BE 7972K117 AND LENGTH 1.50" SHOULD BE 1.25" DLL-#-#-#-25 PIPE P/N 7972K115 SHOULD BE 7972K118 DLL-#-#-#-26 PIPE P/N 7972K115 SHOULD BE 7972K119 AND LENGTH 1.50" SHOULD BE 1.75"		PER VM - This deviation is acceptable. - The fit, form and function of the tool will be as originally intended.																			
<table style="width:100%; border: none;"> <tr> <td style="width:15%; vertical-align: top;"> Environment ☐ Design ☒ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☒ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:15%; vertical-align: top;"> Root Cause No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:20%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:20%; vertical-align: top;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:20%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:20%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>					Environment ☐ Design ☒ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☒ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Root Cause No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
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